

# Work Order ID 63100

October 21, 2010 7:10:39 AM



Page 1

Item ID: D350-604-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Rear Locker Extender

Start Date: 10/22/10 Start Qty: 1.00



Cust Item ID:

Required Date: 11/12/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: CY Date: 10/10/21 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2273	D
D350-604-041	A
DSI9470	A

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D350-604-041 CHG002

8/10/124

110

0.00



PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 12780

Description: D350-604-041 Rear locker extender.

Supplier: Delastek.

Certification of Conformity and process sheet from Delastek is required.

4 x 2600-6 Camlock stud - Ship to Delastek B 115814

CY 10/10/21 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

\* **NOTE:** Date & initial all entries

# Work Order ID 63100

October 21, 2010 7:10:39 AM



Page 2

Item ID: D350-604-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Rear Locker Extender

Start Date: 10/22/10 Start Qty: 1.00



Cust Item ID:

Required Date: 11/12/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120



Packaging

Receive & Inspect for Damage & Mat'l Certs  
Packaging

0.00

Memo

0.00

Packaging

Ensure a copy of Certification of Conformity and process sheet from Delastek is attached.

10/4/23 (1)

130



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Check hole locations to template. DT 8824 Check process sheet and audit.

10/14/23

(10)

140



Packaging

Pick Kit

0.00

Memo

0.00

Packaging

10/14/23 sl

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 63100**

October 21, 2010 7:10:39 AM



Page 3

Item ID: D350-604-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Rear Locker Extender

Start Date: 10/22/10 Start Qty: 1.00



Cust Item ID:

Required Date: 11/12/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

8/6/24

(X)

Quality Control

160

Packaging

0.00



Packaging

Memo

0.00

Identify and pack for shipping as per PPP D350-604-041

Location: 52PPP Rev: 9

10/11/24 SP

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/11/25  
MF  
10-11-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

\* **NOTE:** Date & initial all entries

# Picklist Print

Page 1

October 21, 2010 7:10:39 AM

Work Order ID: 63100

Parent Item: D350-604-041

Parent Item Name: Rear Locker Extender


Start Date: 10/22/10

Required Date: 11/12/10

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:Q03.12.01 Reformat KJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
2600-6  Camlock Stud		Purchased	No			110	Each	76.0000	4	4			

Location	Loc Qty	Loc Code
ST381	76	
114238	4	
114355	4	
115502	4	
115814	64	

D350-604-041P

Purchased

No

120

Each

1.0000

1

1

Rear Locker Extender

Location	Loc Qty	Loc Code
ST	1	
62259	1	

D2268

Manufactured

No

140

Each

13.0000

1

1

Decal

Location	Loc Qty	Loc Code
ST010	13	
60213	3	
62243	10	

D2269

Manufactured

No

140

Each






8.0000

1

1

Decal

Location	Loc Qty	Loc Code
ST010	8	
62244	8	

  
4 10/10/21  
 B6300 10/11/23sf  
 10/11/23sf  
 10/11/23sf  


W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

\* **NOTE:** Date & initial all entries

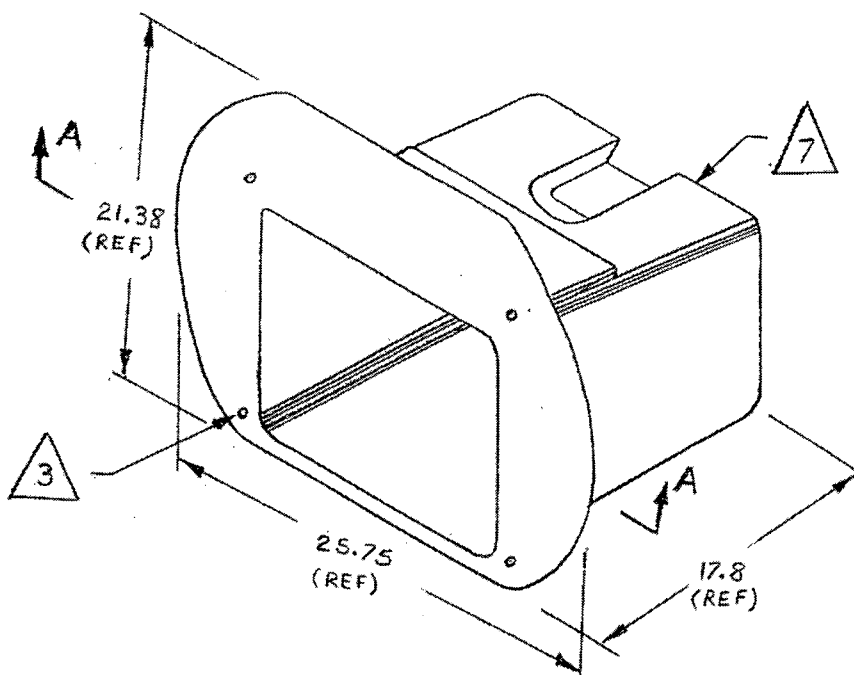




DESIGN	JB	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED		APPROVED	DRAWING NO. D2273	REV. D SHEET 1 OF 1
DATE	02.04.01	TITLE	350 REAR LOCKER EXTENDER	SCALE NTS
B	96.05.27	RE-DRAWN		
C	02.01.30	CLARIFY MATERIAL, LAYUP, AND TOOLING		
D	02.04.01	REMOVE EPOCAST, ADD SURFACE FINISH		

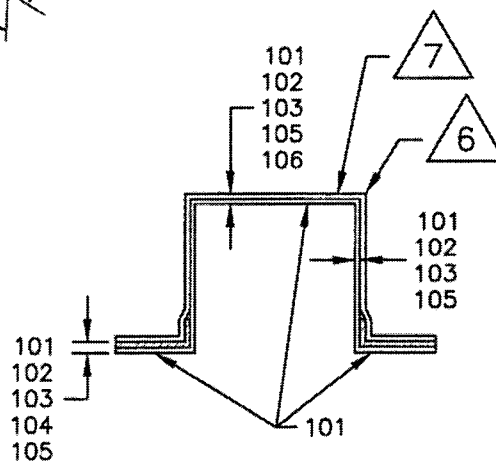
RELEASED  
02.04.03

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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 63100  
C21010121



NOTES:

- 1) LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING.
- 2) LAYUP USING DT8010 MOLD. WET LAYUP NO BAG/VACUUM.
- 3) TRIM & DRILL PER DT8020. OPEN HOLES TO  $\phi 0.257$  (4 PLACES).
- 4) MATERIALS:  
RESIN: DERAKANE 470-36/411/510A40  
FIBRE: 9oz = 9.7 oz 7781 WEAVE "S" GLASS  
18oz = 18.0 oz ROVING "E" GLASS.
- 5) CONSTRUCTION:  
101-WHITE GLOSS GELCOAT # GEL 944W005.  
102-9oz ALL OVER.  
103-18oz ALL OVER.  
104-18oz RE-INFORCE FRONT FLANGE EXTENDING 2" ON SIDES.  
105-9oz ALL OVER.  
106-PEEL PLY.
- 6) MATTE TO HOLD DOWN CORNERS AS REQUIRED.
- 7) FINISH THIS SURFACE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S.
- 8) ALL DIMENSIONS ARE IN INCHES.



SECTION A-A

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# **DART SERVICE INSTRUCTION**

TO AMEND INSTALLATION INSTRUCTIONS D350-604 REV. B

REF TCCA STC: SH90-4

REF FAA STC: SR00463NY

## **PURPOSE:**

The 2600-4 Camloc Studs may be too short for some installations.

## **CHANGE:**

The qty (4) 2600-4 Camloc Studs are replaced with longer 2600-6 Camloc Studs. It is acceptable to install either 2600-4 or 2600-6 Camloc Studs. The parts list of D350-604 Rev. B is amended as follows:

QTY -041	PART NUMBER	DESCRIPTION
X	D350-604-041	REAR CARGO COMPARTMENT EXTENDER ASS'Y

## **IS:**

4	2600-6	CAMLOC STUD
---	--------	-------------

## **WAS:**

4	2600-4	CAMLOC STUD
---	--------	-------------

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WORK ORDER  
NO. 63100

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED

BY: [Signature]  
D. SHEPHERD (DE # 02)

DATE: 09.07.01  
CERT. NO.: SH90-4  
ISSUE NO.: 3

A	NEW ISSUE, NCR 09-046	CP	09.07.01
REV.	DESCRIPTION	BY	DATE
DESIGN	<u>99</u>	<b>DART AEROSPACE LTD</b>	
DRAWN	<u>99</u>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<u>[Signature]</u>	DRAWING NO.	REV. A
MFG. APPR.	<u>NIA</u>	DSI 9470	SHEET 1 OF 1
APPROVED	<u>[Signature]</u>	TITLE	SCALE
DE APPR.	<u>[Signature]</u>	CAMLOC CHANGE	NTS
DATE	09.07.01	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



DESIGN BW	DRAWN BY UP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D350-604-041	REV. A SHEET 1 OF 1
DATE 02.04.01		TITLE REAR LOCKER EXTENDER ASSEMBLY	SCALE NTS
A	02.04.01	NEW ISSUE	
A1	RF 02.04.23	ADD D2728-1 DECAL & ORIENTATION NOTE REAR LOCKER EXTENDER (D2273)	

RELEASED  
02.04.03 [Signature]

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SUBJECT TO AMENDMENT

WITHOUT NOTICE  
WORK ORDER  
NO. 63100

RETAINING WASHER  
2600-LW (4)

AI  
INSTALL D2728-1 DECAL  
IN DEPRESSION ON INSIDE  
BACK WALL

CAMLOCK STUD  
2600-4 (4)

DECAL (D2268)  
TOTAL WEIGHT IN THIS COMPARTMENT  
NOT TO EXCEED 15 LBS (7 KGS)

### D350-604-041 REAR LOCKER EXTENDER

NOTE: DECALS TO BE ORIENTED TO MATCH 'UP' ORIENTATION OF RLE



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Delastek inc.  
2699 5e avenue  
Local 14, Porte -A-  
Grand-Mère, Québec G9T 5K7  
Can \*\* Fax (819) 533-3494 \*\*

# PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	36001
Customer #	DART US

Telephone: (819) 533-5788  
Warehouse: MAIN

Bill to:

DART AEROSPACE LTD  
1270, Aberdeen Street  
Hawksbury, Ontario K6A 1K7  
Canada

Ship to:

DART AEROSPACE LTD  
1270, Aberdeen Street  
Hawksbury, Ontario K6A 1K7  
Canada

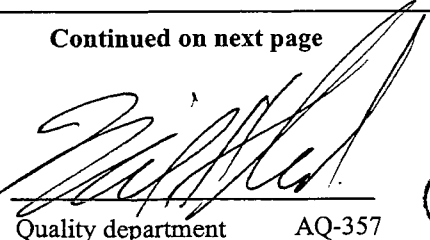
Telephone: 613-632-5200  
Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson	
Puro Collect		Origin		Net 30 days USA		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by		Your PO #	GST/PST #	
22/11/2010	21/10/2010	15813	Chantal Lavoie		PO12780		
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
1	0	1	DKC134-0003	Line #1 Rear Locker Extender D350-604-041P B63099 U de M : Each Référence DKA362-0004 DWG: D350-604-041 REV. A1 D2273 REV. D  <u>No. série</u> B63099  <u>No. lot</u> 29229			
1	0	1	DKC134-0003	Line #2 Rear Locker Extender D350-604-041P B63100 U de M : Each Référence DKA362-0004 DWG: D350-604-041 REV. A1 D2273 REV. D  <u>No. série</u> B63100  <u>No. lot</u> 29230			
1	0	1	DKC134-0003	Line #3 Rear Locker Extender D350-604-041P B63101 U de M : Each Référence DKA362-0004 DWG: D350-604-041 REV. A1 D2273 REV. D  <u>No. série</u> B63101  <u>No. lot</u> 29231			

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

Continued on next page

Accepted by:

  
Quality department      AQ-357

☐ Cust.      ☐ Adm.      ☐ Quality      ☐ Ship.





AERONAUTIQUE

Delastek inc.  
2699 5e avenue  
Local 14, Porte -A-  
Grand-Mère, Québec G9T 5K7  
Can \*\* Fax (819) 533-3494 \*\*

# PACKING SLIP CERTIFICATE OF COMPLIANCE

Telephone: (819) 533-5788

Warehouse: MAIN

Bill to:

DART AEROSPACE LTD  
1270, Aberdeen Street  
Hawksbury, Ontario K6A 1K7  
Canada

Ship to:

DART AEROSPACE LTD  
1270, Aberdeen Street  
Hawksbury, Ontario K6A 1K7  
Canada

Telephone: 613-632-5200

Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson	
Puro Collect		Origin		Net 30 days USA		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by	Your PO #		GST/PST #	
22/11/2010	21/10/2010	15813	Chantal Lavoie	PO12780			
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
1	0	1	DKC134-0003	Line #1 Rear Locker Extender D350-604-041P B63099 U de M : Each Référence DKA362-0004 DWG: D350-604-041 REV. A1 D2273 REV. D  <u>No. série</u> <u>No. lot</u> B63099 29229			
1	0	1	DKC134-0003	Line #2 Rear Locker Extender D350-604-041P B63100 U de M : Each Référence DKA362-0004 DWG: D350-604-041 REV. A1 D2273 REV. D  <u>No. série</u> <u>No. lot</u> B63100 29230  8 10/4/23			
1	0	1	DKC134-0003	Line #3 Rear Locker Extender D350-604-041P B63101 U de M : Each Référence DKA362-0004 DWG: D350-604-041 REV. A1 D2273 REV. D  <u>No. série</u> <u>No. lot</u> B63101 29231			

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

Continued on next page

Accepted by:

Quality department

AQ-357

☐ Cust. ☐ Adm. ☐ Quality ☐ Ship.



Lundi, 2010-09-27 13:01:21

L. Auteur: Pascal Carignan

## Feuille de Procédé

Client	: DART US DART AEROSPACE LTD	Nom Dessin	: REAR LOCKER EXTENDER
Numéro Job	: 29230	Numéro Article	: DKC134-0003
Numéro Soumission	: 3482	Numéro Dessin	: D350-604-041 & D2273
Numéro B.A.	:	Projet Numéro	: DK-362
Cette fois	: 2010-09-27 No. B.V. :	Révision dessin	: A & D
Prsht Rev.	: NC	Matériel	: Derakane 470-36/411/510
Prem. fois	: - - Type :	Date Due	: 2010-10-04 Qté: 1 Udm: UNITE
Job précédente	: 29229		

Écrit par : \_\_\_\_\_  
Vérifié & Approuvé par : \_\_\_\_\_  
Commentaires : N° de pièce Laminée Dart Aerospace: D2273  
N° de pièce Assemblage Dart Aerospace: D350-604-041

**B 63 100**

Process Sheet Rév.: 01 Mise en page selon nouvelle forme.  
Déplacer cette seq. 12 en avant de la seq. 6. Ajouter sablage dans  
seq. Trimage.

## Produit additionnel

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
1.0	AC0085	FREKOTE 3,78L 44-NC

Commentaire Qty.: 0.02 UNITE(s)/Unit Total : 0.02 UNITE(s)

2.0	PRÉPARATION	Préparation du moule
-----	-------------	----------------------



Commentaire Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Nettoyer le moule à l'aide d'un chiffon humide et sécher à l'air. Selon IF DKC134-0003-5.

Note: Afin que le frekote agisse pleinement, le moule doit être libre de toute  
contamination, enlever tout contaminants à l'aide de Frekote PMC, PMC  
Plus ou tout autre solvant efficace. Il est permis d'utiliser un abrasif (Doux)  
afin d'enlever toute accumulation de résine sur le moule.

Appliquer 2 couches de Frekote 44-NC à l'aide du chiffon propre en laissant sécher pendant 15 minutes  
entre les couches. Le séchage de la dernière couche doit être de 3 heures à température de la pièce avant  
d'appliquer le Gel Coat.

Date: \_\_\_\_\_ Sceau: \_\_\_\_\_

3.0	AMB0350	Gel Coat Blanc N° Gel 944W005
-----	---------	-------------------------------

Commentaire Qty.: 1.580 UNITE(s)/Unit Total : 1.580 UNITE(s)  
Gel Coat Blanc N° Gel 944W005 N° de Lot: 1-28605-1

Date: Lundi, 2010-09-27 13:01:21

Utilisateur: Pascal Carignan

## Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: REAR LOCKER EXTENDER

Numéro Job: 29230

Numéro Article: DKC134-0003

Numéro Job:



# Séq.:

Machine ou Opération:

Description :

4.0

AMB0286

Catalyst N° DDM-9

Commentair Qty.: 0.0070 GALLON(s)/Unit Total : 0.0070 GALLON(s)

Catalyst N° DDM-9

N° de Lot: 1-22176-1

5.0

AC0747

Acetone

Commentair Qty.: 0.200 KILOGRAMME(s)/Unit Total : 0.200 KILOGRAMME(s)

6.0

PREP-GENERAL

Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 45.0000Min Total Run : 0.7500Hrs

Tailler le matériel selon les dimensions requises à l'aide de gabarit de trimage prévus à cet effet.

Date: 10-09-10 Sceau:



7.0

PREP-GENERAL

Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Faire la préparation du matériel selon IF DKC134-0003-5 :

Dans une quantité de Gel Coat N° 944W005 ajouter 2% de Catalyst N° DDM-9 et diluer à l'aide de 10% d'acétone.

Date: 8-11-10 Sceau:



8.0

GEL COAT

Application du Gel Coat



Commentair Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs

Selon IF 134-0003.

À l'aide d'un fusil à gel coat appliquer une couche entre 15 et 20 millièmes de Gel Coat sur le moule N° DKG 362-010 et laisser sécher pendant un minimum de 2 heures avant de faire le lay-up, mais ne pas dépasser 24 heures de séchage selon l'instruction de travail N° Tec-70.

Note: Le gel coat ne doit contenir aucun "airdry" ni aucune cire. Et le temp de séchage est important afin d'éviter d'avoir des défauts de surface, et afin d'éviter que le tissu ne vienne marquer au travers du Gel Coat ainsi que d'éviter d'avoir un rétrécissement.

Quantité: 1 Date: 8-11-10 Sceau:



Date: Lundi, 2010-09-27 13:01:21  
Utilisateur: Pascal Carignan

## Feuille de Procédé

Client: DART US DART AEROSPACE LTD  
Numéro Job: 29230

Nom Dessin: REAR LOCKER EXTENDER  
Numéro Article: DKC134-0003

Numéro Job:



# Séq.:

Machine ou Opération:

Description :

9.0 AMB0212 Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 1.680 LITRE(s)/Unit Total : 1.680 LITRE(s)

Résine (411B7530) 411-350 promo. 75min

N° de Lot:

1-28751-1

10.0 AMB0286

Catalyst N° DDM-9

Commentair Qty.: 0.0070 GALLON(s)/Unit Total : 0.0070 GALLON(s)

Catalyst N° DDM-9

N° de Lot:

1-22176-1

11.0 AMB0214

9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish

Commentair Qty.: 4.6 VERGE(s)/Unit Total : 4.6 VERGE(s)

9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish

N° de Lot:

1-27983-1

12.0 AMB0213

WR1850 Roving 18oz. x 50"

Commentair Qty.: 1.140 KILOGRAMME(s)/Unit Total : 1.140 KILOGRAMME(s)

WR1850 Roving 18oz. x 50"

N° de Lot:

1-22302-1

13.0 LAMINAGE

Faire le laminage



Commentair Setup: 0.00Hrs/ Run: 3.5000Hrs Total Run : 3.5000Hrs

Selon IF 134-0003. S'assurer de ne pas trapper d'air entre les rangs.

Inscrire les informations suivantes:

Humidité: 25% Température: 69°F Heure: 12:40

Quantité: 1 Date: 8-11-10 Sceau:



14.0 AMB0212

Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.150 LITRE(s)/Unit Total : 0.150 LITRE(s)

Résine (411B7530) 411-350 promo. 75min

N° de Lot:

1-28751-1

15.0 AMB0286

Catalyst N° DDM-9

Commentair Qty.: 0.0070 GALLON(s)/Unit Total : 0.0070 GALLON(s)

Catalyst N° DDM-9

N° de Lot:

1-22176-1

16.0 FINITION

Finition Générale



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Injecter les bulles d'air selon IF DKC134-0003-5.

Quantité: 1 Date: 8-11-10 Sceau:



17.0 DÉMOULAGE

Démoulage de la pièce



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Selon IF DKC134-0003-5.



Date: Lundi, 2010-09-27 13:01:21

Utilisateur: Pascal Carignan

## Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: REAR LOCKER EXTENDER

Numéro Job: 29230

Numéro Article: DKC134-0003

Numéro Job:



# Séq.:

Machine ou Opération:

Description :

stud.

Quantité: 1

Date: 22 nov 10

Sceau:



25.0

IDENTIFICATION

Identification à encre indélébile



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Selon IF 134-0005 vers l'extérieur

Faire l'identification de la pièce:

N° de pièce D350-604-041

N° de Work Order: # 29230

Quantité: 1

Date: 22 NOV 2010

Sceau:



26.0

INSPEC FINAL

Inspection finale



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire l'inspection dimensionnelle et visuelle de la pièce selon le dessin.

Quantité: 1

Date: 22 nov 10

Sceau:



primer repris 3 fois

27.0

EMBALLAGE

Emballage & Entreposage



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire l'emballage selon IG 0057.

Quantité: 1

Date: 22/11/10

Sceau:

MC

Fab: 22 nov. 2010

Date: Lundi, 2010-09-27 13:01:21

Utilisateur: Pascal Carignan

## Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: REAR LOCKER EXTENDER

Numéro Job: 29230

Numéro Article: DKC134-0003

Numéro Job:




# Séq.:

Machine ou Opération:

Description :

Faire le démoulage de la pièce en poussant de l'air à l'intérieur tout en faisant bien attention de ne pas l'endommager.

Quantité: 1 Date: 9-11-10 Sceau: 

18.0

TRIMAGE



Trimage



Commentair Setup: 0.00Hrs/ Run: 40.0000Min Total Run : 0.6667Hrs

Selon IF 134-0002.

Faire le sablage si nécessaire.

Quantité: 1 Date: 11-11-10 Sceau:  

19.0

AAC1021

Dupont Primer N° 7704S

Commentair Qty.: 0.3400 UNITE(s)/Unit Total : 0.3400 UNITE(s)

Dupont Primer N° 7704S N° de Lot: 1-28050-0

20.0

AAC1101

N° 7775S, Dupont Activator - Reducer Chromabase

Commentair Qty.: 0.0670 UNITE(s)/Unit Total : 0.0670 UNITE(s)

N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: 1-28382-1

21.0


PRIMER

Application primer



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Appliquer le primer selon IG 0008.


Quantité: 1 Date: 18 nov 10 Sceau:  N° fiche de Mélange: 16-0008

22.0

AAC1607

Camlock Stud 2600-4 (or Monadnock 1126000-4)

Commentair Qty.: 4 UNITE(s)/Unit Total : 4 UNITE(s)

Camlock Stud 2600-4 (or Monadnock 1126000-4) N° de Lot:  1-28405-1

23.0

AAC0682

Washer 2600-LW (1127700)

Commentair Qty.: 4 UNITE(s)/Unit Total : 4 UNITE(s)

Washer 2600-LW (1127700) N° de Lot: 1-6697-1

24.0

ASSEMBLAGE

Assemblage mécanique



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Selon IF 134-0004.

Démasquer la pièce.

Assembler les quatre (4) Camlock Stud N° 2600-4 à l'aide des Lock Washer N° 2600-LW selon IG Pose de